

Work Order ID 53421

November 04, 2009 9:18:16 AM



Page 1

Item ID: D2917-1

Accept



Setup Start



Revision ID: B

Item Name: Saddle LH

Stop



Start Date: 11/5/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: *mf* Date: *09-11-04*

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2917	Rev B								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number ☐ Machine Step No 1 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 2 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet ☐ Machine Step No 3 as per Folio

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per Dwg D2917 & attached dimension sheet

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID 53421

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Page 3

Item ID: D2917-1

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Setup Start



Revision ID: B

Stop



Item Name: Saddle LH

Start Date: 11/5/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 11/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-11-20

10

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

09/11/20 10

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.11.23
09/11/20 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 04, 2009 9:18:15 AM

Page 1

Work Order ID: 53421



Parent Item: D2917-1RevB



Parent Item Name: Saddle LH

Start Date: 11/5/2009

Required Date: 11/11/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6102-010RevD		Manufactured	No			100	Each	11.0000	10.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

11

51423

6

52067

5

5
5

mf 09/11/13

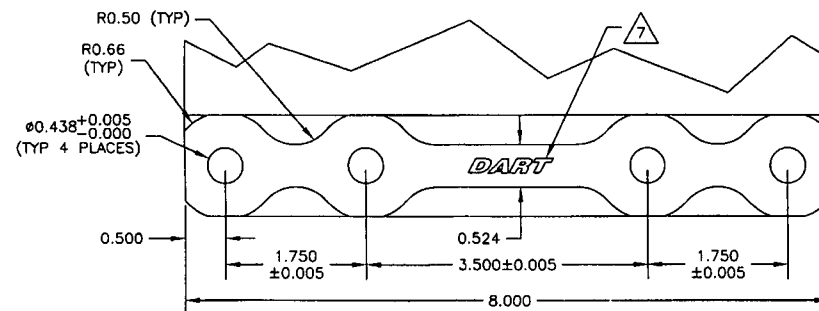
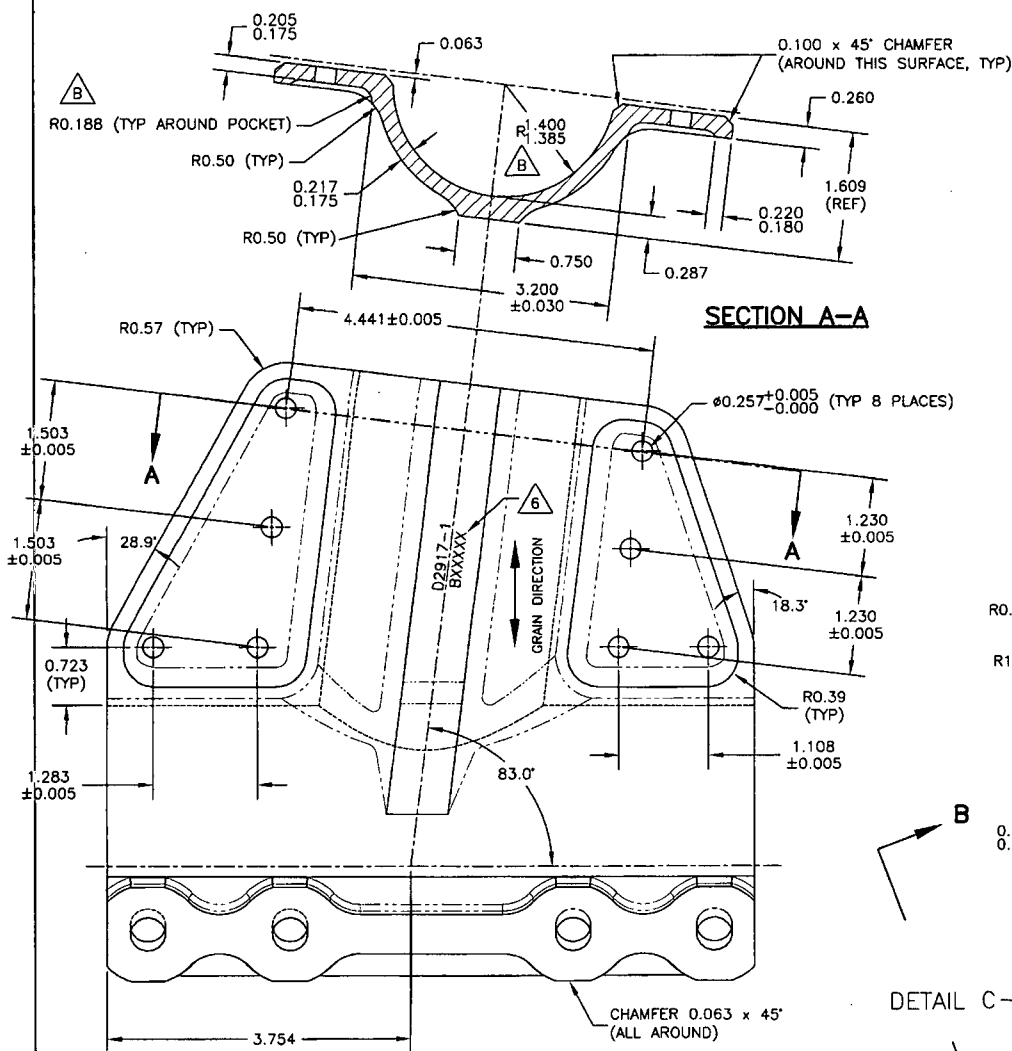
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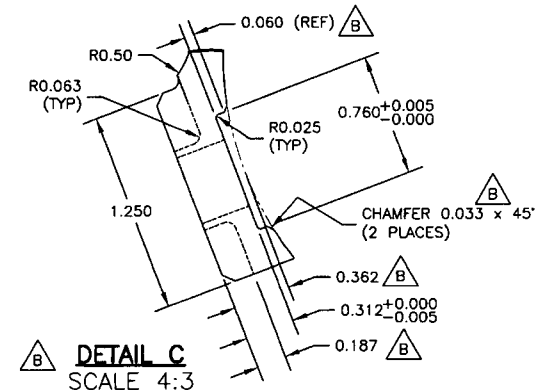
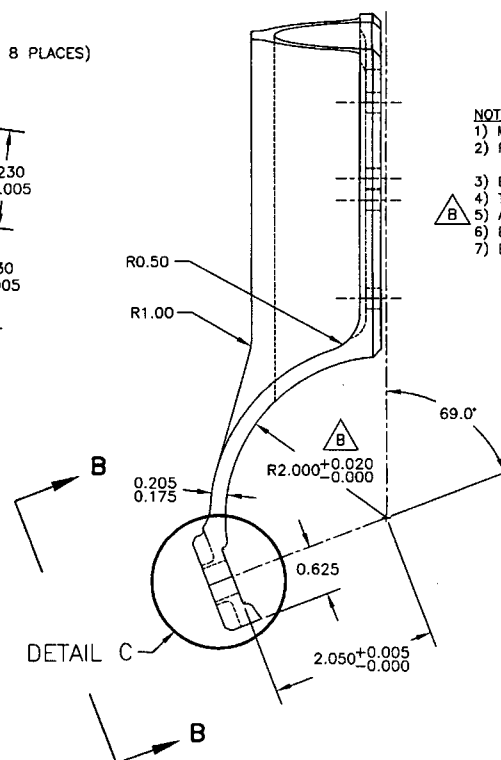
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NOTE: Date & initial all entries



D2917-1 LH SADDLE (SHOWN)
D2917-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



RELEASED

07.07.31

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 DART AEROSPACE LTD.

B	07.06.26	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	9P	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.06.26	TITLE
		SADDLE
		DART AEROSPACE LTD. MARKESBURY, ONTARIO, CANADA
		DRAWING NO. D2917
		REV. B
		SHEET 1 OF 1
		SCALE
		2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 53421
Description: Saddle LH	Part Number: D2917-1
Inspection Dwg: D2917 Rev. A1 <i>AD</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.175	0.205		.195	.189	.188	.183		
B	0.090	0.110		.090	✓	.090	.090		
C	0.250	0.270		.265	.265	.265	.265		
D	1.599	1.619		1.615	1.614	1.615	1.615		
E	0.180	0.220		.180	.180	.191	.190		
F	0.277	0.297		.286	.290	.290	.286		
G	1.385	1.400		1.388	1.387	1.387	1.386		
H	3.170	3.230		3.200	3.206	3.206	3.206		
I	0.175	0.217		.180	.189	.191	.191		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.502	1.502	1.502	1.502		
L	4.436	4.446		4.441	4.441	4.441	4.441		
M	0.257	0.262	DT8683	.260	.260	.260	.260		
N	1.225	1.235		1.230	1.230	1.230	1.230		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	0.470	0.530		.449	.500	.500	.500		
Q	0.438	0.443	DT8682	.442	.443	.443	.443		
R	0.490	0.510		.499	.501	.502	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.001	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.205	.205	.205	.205		
W	1.990	2.010		2.000	2.000	2.000	2.001		
X	0.760	0.765		.763	.763	.763	.763		
Y	0.307	0.312		.312	.312	.312	.310		
Z	0.615	0.635		.623	.623	.623	.623		
AA	0.177	0.197		.186	.183	.187	.187		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SP</i>
Date: 09/11/14

Audited by: <i>MP</i>
Date: 09.11.14

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>JA</i>	<i>SP</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 52421
Description: Saddle LH	Part Number: D2917-1
Inspection Dwg: D2917 Rev. A1 <i>h</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 X	6 2	7 2	8 4	By	Date
A	0.175	0.205		.190	.188	.183	.188		
B	0.090	0.110		.090	.090	.090	.090		
C	0.250	0.270		.265	.265	.265	.265		
D	1.599	1.619		1.610	1.610	1.610	1.615		
E	0.180	0.220		.190	.190	.190	.190		
F	0.277	0.297		.291	.290	.290	.286		
G	1.385	1.400		1.394	1.390	1.390	1.393		
H	3.170	3.230		3.206	3.209	3.209	3.209		
I	0.175	0.217		.190	.190	.191	.188		
J	0.470	0.530		.500	.500	.500	.500		
K	1.498	1.508		1.502	1.502	1.502	1.502		
L	4.436	4.446		4.441	4.441	4.441	4.441		
M	0.257	0.262	DT8683	.260	.260	.260	.260		
N	1.225	1.235		1.230	1.230	1.230	1.230		
O	1.103	1.113		1.107	1.107	1.107	1.107		
P	0.470	0.530		.500	.500	.500	.500		
Q	0.438	0.443	DT8682	.443	.443	.443	.443		
R	0.490	0.510		.502	.500	.502	.500		
S	1.745	1.755		1.750	1.750	1.750	1.750		
T	7.990	8.010		8.000	8.000	8.000	8.000		
U	3.495	3.505		3.500	3.500	3.500	3.500		
V	0.175	0.205		.201	.200	.205	.200		
W	1.990	2.010		2.008	2.000	2.000	2.008		
X	0.760	0.765		.760	.760	.760	.760		
Y	0.307	0.312		.310	.310	.310	.310		
Z	0.615	0.635		.625	.625	.625	.625		
AA	0.177	0.197		.187	.188	.186	.187		
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>SS</i>
Date: 09/11/13

Audited by: <i>mlp</i>
Date: 09.11.14

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	04.09.20	Added DT8683 & DT8682	KJ/JLM <i>h</i>	<i>h</i>

W/O:		WORK ORDER CHANGES					
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Description: Saddle LH	Part Number: D2917-1
Inspection Dwg: D2917 Rev. A1 <i>PSJ</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2917 Rev. A1 and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1X	10X	3	4	By	Date
A	0.175	0.205		.134	.139				
B	0.090	0.110		.090	.090				
C	0.250	0.270		.261	.261				
D	1.599	1.619		1.615	1.615				
E	0.180	0.220		.130	.130				
F	0.277	0.297		.291	.291				
G	1.385	1.400		1.390	1.390				
H	3.170	3.230		3.209	3.210				
I	0.175	0.217		.280	.280				
J	0.470	0.530		.500	.500				
K	1.498	1.508		1.502	1.502				
L	4.436	4.446		4.441	4.441				
M	0.257	0.262	DT8683	.260	.260				
N	1.225	1.235		1.230	1.230				
O	1.103	1.113		1.107	1.107				
P	0.470	0.530		.500	.500				
Q	0.438	0.443	DT8682	.443	.443				
R	0.490	0.510		.500	.500				
S	1.745	1.755		1.750	1.750				
T	7.990	8.010		8.000	8.000				
U	3.495	3.505		3.500	3.500				
V	0.175	0.205		.200	.200				
W	1.990	2.010		2.000	2.000				
X	0.760	0.765		.760	.760				
Y	0.307	0.312		.310	.310				
Z	0.615	0.635		.625	.625				
AA	0.177	0.197		.138	.138				
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <i>PSJ</i>
Date: 09/11/14

Audited by: <i>val</i>
Date: 09-11-14

Rev	Date	Change	Revised by	Approved
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